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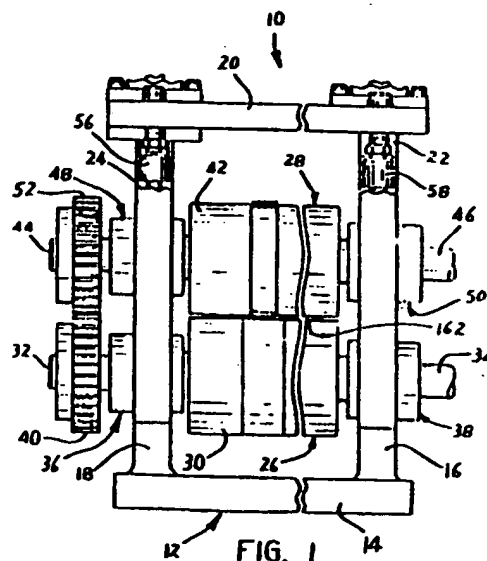
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(54) Apertured nonwoven web.

(57) An apertured, autogenously bonded fibrous web substrate. A nonwoven web contains apertures with a consolidated or densified area surrounding each of the apertures to attract fluid and allow easy passage thereof through the nonwoven web. A novel sanitary napkin containing this perforated nonwoven web cover maintains a cloth-like texture and feel while remaining cleaner and drier during use. Rotary, aperturing apparatus of the present invention performs the process necessary to achieve the desired characteristics in the nonwoven web.



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APERTURED NONWOVEN WEB

TECHNICAL FIELD

The present invention relates, generally, to the field
5 of sanitary napkins for personal feminine care or protection in order to absorb or otherwise contain menstrual fluids or similar exudate, perhaps urine as the consequence of minor incontinence, or the like. The present invention relates more especially to a nonwoven web, particularly one
10 made of fusible polymeric filaments, which is perforated with a patterned multitude of fine heated pins to form consolidated and perhaps occasionally fused openings in the web. This perforated nonwoven web is well-suited for use as the cover or uppermost layer of a feminine sanitary
15 napkin. In addition, this invention relates to an apparatus for perforating a nonwoven web of fibrous fabric to achieve distinct, stable perforations to attract fluid and allow for easy passage of fluid through the nonwoven web.

DESCRIPTION OF THE BACKGROUND ART

20 All manner and variety of sanitary napkins for the absorption of such fluids as menses are, of course, well known. Sanitary napkins, such as those described in U.S. Patents No. 4,397,644 and No. 4,079,379, are well known. Conceptualizing, sanitary napkins of this sort are of
25 multilayered construction including a fluid absorbent core interposed within a backing of a fluid impermeable shield or baffle and a fluid permeable cover, the latter transmitting menstrual fluid or the like across its boundary to the absorbent core. As those skilled in the art will readily
30 appreciate, the interrelationship of components is substantially more intricate; however, for purposes of basic understanding, the foregoing suffices. Within those very general parameters one may also profitably compare the contoured sanitary napkin disclosed in U.S. Patent No.
35 4,184,498.

Conventional sanitary napkins typically comprise an absorbing layer serving as the uppermost layer to be held in contact with the human body and made of a hydrophilic absorbent material such as absorbent paper, absorbent cotton, pulverized pulp or the like, so that when having absorbed therein a large quantity of body fluid, the napkin becomes sticky on its surface. In addition, when the absorbing layer is subjected to pressure, the body fluid once absorbed therein is likely to ooze or flow out reversely toward the body making the surface sticky. Thus, the uppermost layer of the sanitary napkin becomes very uncomfortable to use and unsanitary. This problem is particularly apparent when body fluid is discharged in large quantities within a relatively short period of time in the initial stage of menstruation. The absorbing layer is unable to fully absorb the discharge in some cases, permitting the body fluid to remain on the surface of the absorbing layer and allowing sideways leakage when the layer is subjected to varying body pressures.

Even at times of light flow, however, body fluids do not necessarily readily pass through the fluid permeable cover into the fluid absorbent core of the sanitary napkin. It has been recognized that menses is a complex fluid with uterine blood being only one component of its composition. Menses also contains cellular debris and a mucus-like fraction. The composition of menses has a significant effect on the transport of fluid from the cover into the absorbent matrix of a sanitary napkin, especially for certain women who consistently have high viscosity menses and comparatively low flow volumes. High viscosity menses tends to stay on the upper surface of the cover of the sanitary napkin.

The top or surface layer of sanitary napkins is an important structural component respecting overall product efficacy, both objectively and subjectively from the user's point of view. A number of dichotomies become apparent

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when describing the ideal or preferred top layer of sanitary napkins. For consumer acceptance a cloth-like texture and feel are preferred. In addition, the top layer should appear clean, dry and stain-free even during use. Thus, 5 the cover layer should remain aesthetically pleasing even during use. Nonwoven webs which most economically and effectively achieve the objective of an acceptable cloth-like texture are, however, generally undesirable when evaluated on their ability to remain clean, dry and stain-free during use. 10 With nonwoven webs, menses tends to get hung up or remain on the cover layer of the sanitary napkin while never reaching the lower absorbent layer since the fibers oftentimes act to block the path to the absorbent layer. Thus the sanitary napkin becomes uncomfortable, 15 wet, sticky and generally unaesthetically pleasing.

SUMMARY OF THE INVENTION

The present invention advantageously provides an improved top layer or cover for a sanitary napkin which has 20 a cloth-like texture or feel but which remains clean, dry and relatively stain-free during use, in contradistinction to conventional fibrous covers. A particular beneficial attribute of the cover in accordance with the present invention is that it has the ability to relatively rapidly 25 transfer menses across its boundaries into the absorbent material lying beneath it while preventing the return of that fluid to the cover; i.e., the improved cover of the present invention has excellent rewet characteristics. Webs or covers of the foregoing variety are conveniently 30 and beneficially provided in a fairly simple manner using straightforward apparatus. Thus, capital expense and elaborate methodologies are minimized while nonetheless delivering product of enhanced characteristics as aforesaid. Still further, the cover of the present invention 35 optionally provides means for improved stain masking, either integrally or in association with the absorbent core or

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matrix of a sanitary napkin, increasing significantly the aesthetic characteristics of this class of catamenial product.

The foregoing advantages and benefits are achieved, in one aspect of the present invention, by means of a nonwoven web comprising essentially broken thermoplastic fibers wherein the nonwoven web contains distinct, stable perforations with a consolidated zone or area of densified, thermally set material immediately surrounding each such perforation. The fibrous web substrate is most preferably autogenously bonded and thus does not require an ancillary adhesive. When the perforated, selectively or discretely consolidated nonwoven web is adopted as a cover material for a sanitary napkin, the perforations tend to attract body fluid (i.e., menses), and thus allow for relatively easy passage of the fluid through the web into the absorbent area of the napkin.

A novel rotary, perforating apparatus provides the desired apertured nonwoven web system of the present invention. In a particularly preferred aspect thereof, matting pin/hole rolls suitably heated relative to the physical characteristics of the web to be apertured provide an expedient apparatus and convenient method for achieving the ends of the present invention.

Other advantages of the present invention, and a fuller appreciation thereof, will become apparent as the following detailed description ensues.

BRIEF DESCRIPTION OF THE DRAWINGS

This invention can better be understood by references to the drawings in which;

FIGURE 1 is a cross-sectional view through the length of the rotary, perforating apparatus of the present invention.

FIGURE 2 is a partial cross-sectional view through the drive side of the apparatus shown in FIG. 1.

FIGURE 3 is a partial cross-sectional view through the operator side of the apparatus shown in FIG. 1.

FIGURE 4 is a cross-sectional view through the pin roll of the apparatus shown in FIG. 1.

5 FIGURE 5 is a cross-sectional view through the hole roll of the apparatus shown in FIG. 1.

FIGURE 6 through FIGURE 11 are views of various types of pins which are useful in the practice of the present invention.

0 FIGURE 12 is a cross-sectional view of a shouldered pin shown to be perforating an area of nonwoven web comprising thermoplastic fibers.

FIGURE 13 is a view from the bottom of the nonwoven web of FIG. 12 after the pin has been removed.

5 FIGURE 14 is a cross-sectional view through the hole roll and each of the pin rolls is a multi-roll system showing the path of the nonwoven web.

FIGURE 15 is a plan view of the top or cover layer of a feminine sanitary napkin depicting the pattern of the perforations.

10 FIGURE 16 is a plan view of the top or cover layer of another feminine sanitary napkin depicting the pattern of the perforations.

15 DETAILED DESCRIPTION OF THE INVENTION

Any type of nonwoven web comprising fusible polymeric filaments is useful in the practice of the present invention. For instance, a suitable nonwoven web cover material is a uniform spunbonded nonwoven web having one and
30 one-half denier or larger filaments. Such a material is described in U.S. Patent No. 4,340,563, to which reference is made for a fuller description of such material. This material is also referred to as linear drawn spunbonded (LDS).

35 Alternatively, a bonded carded web is useful in the practice of the present invention. The bonded carded web

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is most generally composed of 100% polypropylene, however, blends containing rayon, polyester and the like are equally suitable. Hollowfill fiber types may also be present in the bonded carded web. The bonded carded web is generally
5 in the range of about ten to about fifty gsm (grams per square meter) and is preferably within the range of about 18 to about 24 gsm. The bonded carded web fibers range from about one and one-half to about three denier. The staple length is within the range of about one and one-half
10 to about two inches. Alternatively, the bonded carded web may be laminated to a film of ethyl methacrylate.

Another suitable nonwoven web is a "coform" material as described in U.S. Patent No. 4,100,324. Coform is a blend of meltblown microfibers and an absorbent fiber such
15 as pulp fluff. Representative meltblown fibers include polypropylene, polyethylene, polyethylene terephthalate, polyamides, acrylic or nylon fibers or blends. Alternatively, the coform may be laminated to a spunbonded nonwoven web.

20 A sanitary napkin cover such as that described in U.S. Patent No. 4,397,644 is also useful in the practice of the present invention. The material described therein is primarily a nonwoven thermoplastic web which is of sufficiently open structure to enhance the transfer of menses
25 into an absorbent layer. Bonding is used to accomplish integration. This may be achieved by the application of heat, such as hot calendar embossing, or by ultrasonic means. Alternatively, the bonding may be accomplished by mechanical manipulation of the fibers with or without heat
30 as, in needling. Ultrasonic bonding is particularly preferred. This nonwoven web is typically comprised of a polyester and polypropylene combination, typically 30% and 70% respectively. Alternatively, it may be comprised of 100% polypropylene. Hollowfill fiber types may also be
35 present. This nonwoven web is a carded web which is generally in the range of about 30 to about 150 gsm.

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Preferably, this nonwoven web ranges from about 40 to about 120 gsm. This material ranges from about one and one-half to about eight denier and may be of a high crimp nature thus giving it greater loft. Preferably, it is within the range of about 3 to about 8 denier. The staple length is also within the range of about one and one-half to about three inches. This material may alternatively be laminated to a spunbonded web.

In particular, suitable fusible fibers for this invention are: Vinyon, a vinyl chloride/vinyl acetate copolymer sold by Celanese Fiber Division and formerly by Avtex Fibers Inc. of New York, N.Y.; Eastman 410 amorphous or crystalline polyester fibers sold by Eastman Chemical Products, Inc., a Subsidiary of Eastman Kodak Co., Kingsport, Tenn.; or Chisso ES a bicomponent polypropylene/polyethylene fiber sold by Chisso Ltd., Osaka, Japan, which due to its differential melting point for each component of the fiber, could be used as the only thermoplastic fiber as well as in blends with other fibers.

A cylinder which would simply punch holes through and displace fiber is easily achieved. However, the nonwoven web material typically has a memory and thus a strong tendency to return to its original position and thereby close the hole which was just formed.

It has been found that heating the tips of the pin to heat the nonwoven web during penetration acts to heat the fusible polymeric filaments near the area of the pin hole. The polymeric filaments are heated up to a temperature just below the point of melting and cooled to room temperature after the pin is removed. This produced the consolidated area 168 seen in FIG. 12 and FIG. 13. The fusible thermoplastic fibers used in the nonwoven web are meltable and if sufficient heat and pressure are applied to this nonwoven material selected areas will consolidate or tend to melt and lose the fibrous network characteristics of nonwoven materials. Under magnification of 20X, the

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material appears glassine, almost glass-like in appearance. This consolidated or densified area of the material is now hydrophylic and attracts fluid into the perforation or hole. Of course, it is possible that some areas will
5 actually melt and fuse during the course of the subject operation, but this is deemed to be less desirable in the practice of the present invention.

It is also relevant to note that it is not desirable to simply make a hole that removes or evaporates the
10 material previously in the hole or aperture area and thus leaving a solid clean hole in the fabric. The goal of the present invention is to allow all of the material or nonwoven fabric to remain in the web because it is desirable to create some type of depth at the point of penetration.
15 This depth is desirable since it allows a perception of thickness or texture to the nonwoven fabric.

Ideally, by making the apertures in the nonwoven web in the manner taught by the present invention, little ridges 170 or raised areas form around the periphery of the
20 consolidated portions of the apertures. To some extent, this is depicted in FIG. 12 and FIG. 13 where the nonwoven material which has not become consolidated or densified, 170, is fluffier and thicker and therefore appears like a ridge adjacent the consolidated area. This ridged area is
25 ideally considerably less acceptable to fluid or menses since the menses can readily get hung up or stuck on the upper surface of the ridged portion and be unable to enter the absorbent area below. Generally, the heavier the fabric, the higher the ridge will be. Advantageously,
30 since the consolidated areas are more hydrophylic, the menses will be attracted to these areas and then readily pass through the apertures or holes directly into the absorbent area below.

Preferably, the heated pin makes a distinct, true hole
35 through the nonwoven web fabric. That is, no fibers remain in the hole itself. The hole should be free from any

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extraneous fibers or impurities. If a glob of fluid enters an aperture blocked by a few fibers, the glob of fluid will get hung up on the top of the nonwoven layer and remain in that position blocking the entrance of the hole. This is
5 obviously undesirable since it leaves an undesirable stain and wetness on the surface of the nonwoven cover.

The sides of the aperture or perforation thus formed are preferably at approximately a 90° angle which respect to the length of the nonwoven fabric.

10 Briefly, the apparatus of the present invention may be envisioned as any type of perforating or aperturing device having a member or portion containing a series of pins and another member or portion containing a series of indentions for receiving entry of the pins. Preferably, the apparatus
15 of the present invention is a rotary perforating or aperturing system with the capability of generating a combination of holes having a variety of shapes and in a wide range of patterns with a single pass of the nonwoven web through the system. The rotary perforating/aperturing
20 system can be described as a system comprising two or more cylinders mounted in a configuration such that one or more cylinders are associated with the peripheral surface of a single main cylinder.

The main cylinder can be described as a hole roll
25 which has been machined or engraved for finished female pattern design. The cylinder is heated internally and the surface is hardened to withstand embossing pressure.

A pin roll is also cylinder machined to a finished male pattern design for perforating the web. This matches
30 the hole roll cylinder and is equipped with tools, for example, perforating pins, embossing pins or a combination of both. The pin roll cylinder is also heated internally.

A perforating apparatus 10 as shown in FIGS. 1-3 comprises a frame 12 which includes a horizontal base 14, a
35 pair of vertical side walls 16, 18, and a top member 20 extending across the upper end of the side walls. The side

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walls 16, 18 include vertical slots 22, 24, respectively. Mounted within the slots are a pair of roll assemblies 26, 28. A lower one 26 of the roll assemblies includes a hollow roll 30, and a pair of support shafts 32, 34 extending horizontally coaxially from opposite ends of that lower roll 30. One of the shafts 32 is journaled in a bearing mechanism 36 mounted in the slot 24 of the side wall 18.

The shaft 32 projects completely through the slot 24 and is operably connected to a toothed gear 40. The other shaft 34 extends completely through the slot 22, journaled in bearing housing 38, and is of hollow construction for the purpose of receiving electrical conduits as will be hereinafter explained.

An upper one 28 of the roll assemblies is shown in FIG. 4 to include a pin roll 42 and a pair of support shafts 44, 46 extending longitudinally coaxially from opposite ends of that upper roll 28. One of the shafts 44 is journaled in a bearing mechanism 48 mounted in the slot 24, and the other shaft 46 is journaled in a bearing mechanism 50 mounted in the slot 22.

The shaft 44 projects completely through the slot 24 and is operably connected to a toothed gear 52 which meshingly engages the gear 40. There is a zero backlash arrangement. Shaft 46 is driven by a power source through a controllable speed variator. The other shaft 46 extends completely through the slot 22 and is hollow in order to receive electrical conduits as will be hereinafter explained.

Spacer 160 is used to fix the spaces. This determines how much penetration is obtained from the pin into the hole roll.

The bearing mechanisms 48, 50 are each vertically adjustable within the respective slots 24, 22 by means of turnbuckle type connectors 56, 58. In that manner, the upper roll or pin roll 42 can be raised and lowered relative to the lower roll or hollow roll 30 to change the

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vertical depth of the nip defined between the rolls, and also for maintenance and replacement of parts.

The lower roll comprises an arbor 60 as shown in FIG. 5, upon which a sleeve 62 is mounted by means of keyway.

5 The sleeve is formed of a heat conducting material, typically brass, steel or aluminum. Aluminum is preferred. The sleeve is axially sandwiched between a terminal ring 64 and a retaining ring 66. The retaining ring is pushed against the sleeve 62 by turnbuckle type connectors 68
10 which extend between the retaining ring 66 and an end ring 70 which is mounted on the arbor 60. The terminal ring 64 is positioned axially between the sleeve 62 and another end ring 72 mounted on the arbor 60.

The outer periphery of the sleeve 62 is stepped at its
15 ends to define annular shoulders 74, 76 which receive the inner ends of a pair of cover rings 78, 80. The cover ring 78 engages the shoulder 74 and the outer peripheries of the end ring 70 and the retaining wall 66 and is suitably fastened to the end ring 70 and to the sleeve 62 by fasten-
20 ers 82, 84. The cover ring 80 engages the shoulder 76 and the outer periphery of the end ring 72 and is suitably fastened thereto by fasteners 86, 88.

The sleeve 62 contains a conventional electrical cartridge heater 90 which is electrically connected to an
25 external power source via electrical conduits 92, 94 which are interconnected by terminals 96 carried by the terminal ring 64. The cartridge 90 can thus be heated in order to transmit heat to the sleeve 62. The sleeve 62 also carries a conventional probe 98 for monitoring the temperature of
30 the sleeve 62.

Mounted on the outside periphery of the sleeve 62 is a cylindrical strip also referred to as the hole roll 100 formed of a heat conducting material such as brass, steel or aluminum with aluminum being preferred. The strip is
35 mounted on the sleeve by press fit, and a roll pin 102 is inserted through the strip and the sleeve 62 to prevent

relativ circumferential movement there between. Axial movement of the strip 100 is prevented by the cover sleeve 78, 80 which bear against axial ends of the strip 100. The strip contains a series of tiny openings or sockets arranged in a pre-set pattern for reasons to be explained hereinafter.

The upper roll 42 comprises an arbor 110 upon which a sleeve 112 is mounted in the same manner as the sleeve 62 of the lower roll. The sleeve is formed of a heat conducting material, such as brass, steel or aluminum, and is axially sandwiched between a terminal ring 114 and a retaining ring 116. The retaining ring is pushed against the sleeve 112 by turnbuckle type connectors 118 which extend between the retaining ring 116 and an end ring 120 which is mounted on the arbor 110. The terminal ring 114 is positioned axially between the sleeve 112 and another end ring 122 mounted on the arbor 110.

Extending around opposite ends of the arbor are a pair of cover sleeves 124, 126. The cover sleeve 124 is secured to the outer peripheries of the end ring 120 and the sleeve 112 by means of fasteners 128, 130. The cover sleeve 126 is secured to the outer peripheries of the end ring 122 and the sleeve 112 by means of fasteners 132, 134.

The sleeve 112 contains a conventional electrical cartridge heater 140 which is electrically connected to an external power source via electrical conduits 142, 144. Those conduits 142, 144 are interconnected by terminals 146 carried by the terminal ring 114. The cartridge heater 140 can be heated in order to transmit heat to the sleeve 112. The sleeve 112 also carries a conventional probe 148 for monitoring the temperature of the sleeve 112.

Mounted on the outside periphery of the sleeve 112 is a cylindrical strip 150 formed of a heat conducting material such as brass, steel or aluminum, with aluminum being preferred. The strip is mounted on the sleeve by press fit, and a roll pin 102 is inserted through the strip

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150 and the sleeve 112 to prevent relative circumferential movement therebetween. Lip portions 154, 156 of the cover sleeves 124, 126 overlap the edges of the strip 150 to aid in the retention thereof.

5 The strip 150 carries a plurality of needles or pins 152 which project outwardly beyond the outer peripheries of the cover sleeves 124, 126 by a distance greater than the depth of the nip between the rolls so that the ends of the pins 152 enter the sockets in the lower roll 30. To that
10 end, the sockets in the strip 100 of the lower roll or hollow roll 30 are arranged in register with the pins 152 and are of a wider diameter than the pins to prevent the pins from contacting the walls of the sockets. It will be appreciated from the foregoing that the upper roll or pin
15 roll 42 may be designated as a pin roll, and the lower roll 30 as a hole roll. Preferably, the pins 152 are formed of a heat conductive material such as brass or steel. The pins 152 are mounted within the strip 150 by placement either from the inside of or from the outside of the
20 cylinder. Placement of the pins by the outside of the cylinder generally requires a space for setting of the pins and the use of a type of compound that upon filling the space provides an element of permanence to the setting, thereby not allowing the pins to be removed. The strip 150
25 includes a recess 158 facing the sleeve 112 to receive the inner ends of the pins. The pins 152 project in radial directions with respect to the axis of rotation of the pin roll 42. The sockets in the strip 100 project in corresponding directions so as to be able to receive the ends of
30 the pins.

It will be appreciated that the pins are heated by conduction due to contact between the heated sleeve 112 and the strip 150 and between the strip 150 and the inner ends of the pins 152. The corresponding roll is heated in a
35 similar manner.

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In operation, the rolls 30, 46 are synchronously rotated while a web 162 of fabric is fed through the nip defined by the rolls. As this occurs, the pins 152 contact and completely penetrate the fabric, separating the individual fibers to form a generally cylindrical hole through the fabric. Since the pins are heated, the fibers which are displaced by each heated pin will be consolidated, compressed or otherwise densified and set in that glassine-like configuration so that the hole cannot reclose. Thus, the fibrous web is autogenously bonded, that is, does not require the use of an adhesive to form structurally stable apertures. Some portion of the fibers being pushed will enter the associated socket in the socket hole, whereby an annular ridge or rise will be formed around each of the holes on the surface of the web which engages the hole roll. Such rises serve to add depth to the web and thereby improve the cloth-like texture and feel.

Since the pins 152 pass completely through the fabric and tend to set thermally any fiber with which they come into contact, it is assured that all of the holes will be unblocked, i.e., no fiber strands will remain which might extend across, and partially obstruct, the holes.

Nonwoven web fabric 162 may enter the apparatus 10 from either side of the two cylinders.

The foregoing describes a two cylinder configuration with a female patterned main cylinder and a male patterned worker cylinder, however, other embodiments are anticipated such as a three cylinder configuration where the three cylinders may or may not relate in a linear fashion. By using a multiple cylinder configuration a wider variety of patterns can be attained since different male or pin rolls may be used. That is, the male or pin rolls need not be of the same shape or diameter. This is best depicted in FIG. 14 wherein there are three peripheral male or pin rolls.

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For purposes of the present discussion, the male roll will be referred to as the pin roll and the related female roll will be called the hole roll. At the outset it is relevant to note that the temperature of the heated pin
5 roll may be higher than that of the hole roll without departing from the spirit of the present invention. This is because approximately 10% of the heat from the pin roll may be lost at the tips of the pins, but without a loss in overall operating or functional efficiency. Of course, the
10 two rolls may be maintained at about the same temperature. There is no easy means of actually heating the tips of the pins thus it is necessary to heat the pin roll itself and via conduction drive heat to the pin head to perform the aperturing operation of the present invention. The
15 temperature of the pin roll may generally be maintained in the range of about 110°F. to about 300°F. The hole roll, on the other hand, may generally fall within the temperature range of about 90°F. to about 350°F.

The speed of the rotary apparatus is generally within
20 the range of about 12 feet of nonwoven fiber per minute to about 220 feet per minute. Since we are dealing with a rotary process, if parameters such as heat, angle of approach of the pin, and the like are controlled, speeds up to approximately 500 feet per minute could conceivably be
25 achieved.

It may be considered suitable to thermally treat nonwoven web prior to processing via the apparatus of the present invention. The web may be pre-cooled or post-cooled, that is, cooled after undergoing the perfora-
30 tion operation.

Generally, if the speed of a nonwoven web through the rotary apparatus is increased, the temperature must also be increased. These two parameters are directly related since the web may actually burn if the temperature is too high
35 and the pin and the web maintain contact for too long. Preferably, an electrical mechanism is used which is able

to maintain both parameters of temperature and speed in the ideal or best relationship.

It is also particularly relevant to note that during the rotary operation, the pins never touch the interior of the corresponding hole on the hole roll. The individual hole diameters in the hole roll are most preferably always approximately 0.010 inch larger than the diameter of the pin shaft. This is area 172 in FIG. 12. At a minimum, the hole diameter is selected to be nonbinding respecting the size of the mating pin, typically at least 0.005 inch greater than the diameter of the pin shaft on the pin roll. This spacing is important in the practice of the present invention in order to achieve the proper depth of entry of the pin through the nonwoven web fabric. Otherwise, if the pin head was too long, it might touch the sides of the hole.

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FIG. 6 through FIG. 11 each depict a pin which is of varying sizes and shapes. However, each of these pins are suitable for forming the apertures in the nonwoven web of the present invention. Each pin may be located on a flat plate type of device or placed on some type of rotary cylinder as was previously described. The hole in the hole roll need not be of the same shape as the pin or pin head. As long as the proper relative dimensions are maintained to preclude binding or interference, the hole may be less defined or more rounded than the pin shape.

FIG. 11, FIG. 12 and FIG. 14 depict a shouldered pin 166 which is a suitable pin in the practice of the present invention.

The exact shape and dimensions of the pin head are not critical for present purposes. However, the diameter of the shaft 164 of the pin is important. The shaft 164 of the pin is most relevant since it determines the diameter of the aperture which is formed. Generally, the diameter of the shaft of the pin ranges from about 0.015 to about 0.125 of an inch. Preferably the pin shaft ranges from

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about 0.032 to about 0.097 of an inch. The pins essentially act to burst the nonwoven fabric while not actually damaging or breaking any of the fibers themselves.

The pin itself is comprised of a metal. Preferred
5 metals include steel or brass with steel being more preferred. Any type of steel is suitable in the practice of the present invention including hard or soft steel such as stainless steel. The preferred metal is one which would allow the greatest heat transfer from the heated roll to
10 the pin head.

A plastic pin or pin head may be desired in the practice of the present invention at the option of the designer. However, some plastics are generally not able to withstand the high operating temperatures as described
15 herein and materials selection needs to be made accordingly.

Alternatively, the pin may comprise a metal core such as steel with a plastic surface. The plastic covering may be applied by coating or it may be mechanically fit by
20 pushing the coat or layer onto the pin. The plastic coated metal pin concept is particularly advantageous since the plastic surface provides a smooth, slippery surface to the pin thus allowing it to penetrate the nonwoven fabric more readily. A preferred coating material would be a
25 fluoropolymer coating, in particular, polytetrafluoroethylene (Teflon® by Dupont).

A metal pin may also be impregnated with plastic material. In this case, the metal surface must be porous enough to allow the actual impregnation of the plastic onto
30 the metal. Suitable plastic materials for this impregnation include, but are not limited to, polypropylene, polyethylene and the like.

Every one of the pins must enter the matching hole on the hole roll with perfect clearance. There is never any
35 metal-to-metal, or in the case of plastic coated pins, plastic-to-metal contact.

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The diameter of the shaft of the pin is generally in the range of 0.015 inch to about 0.125 inch. This is the true diameter of the tool therefore this value does not necessarily represent the diameter of the finished hole.

- 5 The finished hole may be slightly oblong and slightly larger than the diameter of the pin shaft when completed. The exact diameter of the hole is dependent on a variety of factors that must be each independently determined.

- 10 In determining the number of holes per area on the nonwoven web it is pertinent to discuss the percent of openness, as that is a more meaningful value than the pin population per square inch since pin diameter varies so widely. The goal is to open and texturize the surface of the nonwoven to allow fluid menses to penetrate more
15 readily while at the same time to minimize rewet, that is, a return of the fluid to the nonwoven cover. Maintaining a product which is aesthetically pleasing is thus a key to the present invention.

- 20 The degree of openness or perforation on the nonwoven web can range from about 20% to about 55% of the available surface area. The upper practical limit seems to be approximately 55% due to mechanical/physical limitations of the system. Preferably, the degree of openness is in the range of about 40% to about 50%.

- 25 The pattern of the pins themselves may vary considerably. If a smaller shaft size is selected, a greater number of holes are necessary to achieve the same degree of openness.

- 30 It is also suggested to add a binder to the intact area of the nonwoven web, that is, the area between the holes or apertures. This has been described as the ridge area. The addition of a binder has a two-fold advantage. First, the binder will not destroy the cloth-like texture and appearance of the nonwoven web. Second, by filling in
35 the tiny voids within the ridges, fluid will not have a tendency to get hung up there and therefore alter the

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visual appearance of the surface of the sanitary napkin. Th binder may be applied at any stag of th process such as during the formation of the nonwoven web, sprayed on after the web is formed or added during the aperturing or
5 consolidating process. The optimal qualities of a binder is that it withstand body temperature heat, but neither melt nor rub off. Suitable binders include polyethylene glycol and the like.

Another feature of the subject invention involves
10 color toning or pigmenting either the area of aperturing or the entire top surface of the sanitary napkin which may or may not contain the apertures of the present invention. This color toning or pigmenting of the cover layer has several advantages. Most significantly, it tends to affect
15 perceptual or visual masking of fluid during use of the sanitary napkin. The coloring may thus attenuate the typical red menstrual stain observable during use. It also improves visual perception by emphasizing in the case of a perforated nonwoven cover material that the product is
20 effective in achieving a degree of physical separation between the body of the wearer and the core containing or laden with menstrual fluid. The perforations also become more distinct and noticeable. The coloring or pigmenting is selective and may involve all or a portion of the
25 nonwoven cover material. The preferred colors include those in the blue, blue-green, and green areas of the visual light spectrum. Alternatively the toning or coloring agent may be already present in the binder. In addition, instead of toning or pigmenting the cover layer
30 itself, a similar effect could be achieved by toning or pigmenting the absorbent material directly under the cover layer.

If a more conventional white coloration is desired a whitening or opacifying agent may b used such as titanium
35 dioxide (TiO_2) up to a level of approximately 8% of the total w ight of the cover material.

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As previously indicated, the aforementioned aperture d nonwoven web is suitably the uppermost or cover layer of a feminine sanitary napkin. The ridges 170 as shown in FIG. 12 face the perineal area of the wearer when the nonwoven web is used as a cover on a feminine sanitary napkin. Any sanitary napkin bearing a fibrous cover currently known in the art may contain the apertured nonwoven web cover material of the present invention. In the simplest terms, a feminine sanitary napkin is comprised of a highly absorbent core of fibrous material or the like, a fluid pervious cover member such as that described by the present invention and a fluidimpervious backing member which is oftentimes referred to as a baffle, with pressure sensitive attachment means disposed thereon. The highly absorbent core of fibrous material may comprise any of the well-known materials currently known in the art, including wood pulp fluff, multiple layers of cellulose wadding, cotton or rayon fibers, cellulose sponge, hydrophilic synthetic sponge, and the like.

The fluid impervious backing member or baffle is preferably a thin plastic film such as polyethylene or polypropylene of about one-half to three mils (i.e., thousandths of inches) in thickness. Other thin flexible films such as polyvinylchloride, polyvinylidene chloride, natural rubber, etc. may be employed. Another useful material is a thin polyurethane film which may be of open or close-celled construction on the interior, and may be absorbent or nonabsorbent, but which should have a closed fluid-impervious skin on at least the bottom surface.

Exemplary of such a baffle is a conventional 0.4 oz. per square yard spunbonded web with a 0.75 mil (0.00075 inch) film of an ethylene methyl acrylate (EMA), preferably with the EMA side toward the body of the absorbent material.

According to this invention, the sanitary napkin is provided with improved comfort and the ability to

relatively rapidly transfer viscous materials from the apertured nonwoven web cover material into the absorbent layer below. The absorbent matrix described in U.S. Patent No. 4,397,644 contains a principal absorbent component characterized by relatively high fluid retention and a second component including comfort enhancement capabilities positioned at least in part between the principal absorbent and the fluid permeable cover or wrap. The second component, that is the comfort enhancing component, may be integrated with the apertured nonwoven web cover material of the present invention to provide intimate contact and densification of localized regions. As a consequence, fluid transfer routes are established and fluid is conveyed to the principal absorbent component. This fluid transfer system may be used in association with the nonwoven web cover of the present invention.

FIG. 15 and FIG. 16 indicate two possible designs or patterns for the apertured holes on the surface of the cover material of the sanitary napkin. Looking at the length of the sanitary napkin, the range of the width of the apertured material is generally from about one to about two inches wide, that is, the apertures do not extend the full width of the sanitary napkin. This can be observed at areas 174 and 180 of FIG. 15 and FIG. 16. The area without aperturing is generally about 0.75 inch to about 2.0 inch wide on each side of the sanitary napkin.

Alternatively, a distinct registered pattern may be obtained on the sanitary napkin cover. That is, the apertured pattern of approximately one to two inches wide need not extend the full longitudinal length 178 of the sanitary napkin as described in FIG. 16. Typically the aperturing may be terminated from 3/4 inch to approximately 2 inches from the longitudinal edge of the pad. In the case of the registered pattern the apertured portions of the cover material do not touch the edges of the sanitary napkin and is primarily located in and near the center of the sanitary

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napkin. This is obviously most advantageous since it corresponds with the perineal area of the wearer. In FIG. 15, the aperturing 176 extends the full longitudinal length of the sanitary napkin.

5

While the invention has been described in connection with preferred embodiments, it will be understood that it is not intended to limit the invention to those embodiments. On the contrary, it is intended to cover all alternatives, modifications, and equivalents as may be included within the spirit and scope of the invention as defined by the appended claims.

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WHAT IS CLAIMED IS:

5 1. A shaped article which comprises an apertured, autogenously bonded fibrous web substrate, said substrate comprising a nonwoven web network including essentially unbroken thermoplastic fibers, said substrate having a plurality of apertures extending therethrough, and said substrate comprising consolidated autogenous bonds conjoining said thermoplastic fibers at points contiguous the peripheries of said apertures.

2. A shaped article according to claim 1, wherein the nonwoven web comprises polypropylene.

3. A shaped article according to claim 1, wherein the nonwoven web comprises a spunbonded fiber.

4. A shaped article according to claim 1, wherein about 20% to about 55% of the entire surface area of the nonwoven web is apertured.

5. A sanitary napkin comprising a layer of absorbent material supporting a cloth-like fluid-permeable cover, said cover comprising a shaped article according to claim 1.

6. A sanitary napkin according to claim 5 wherein the width of the pattern of perforations is within the range of about one to about two inches.

7. A sanitary napkin according to claim 5, wherein the length of the pattern of perforations on the cover extends to the longitudinal ends of the sanitary napkin.

8. A sanitary napkin according to claim 5, wherein the length of the pattern of perforations on the cover falls greater than 3/4 inch from the longitudinal ends of the sanitary napkin.

9. A sanitary napkin according to claim 5, wherein color toning or pigmentation is present on the top surface of the cover material of the sanitary napkin to mask undesirable color or stain.

10. A sanitary napkin according to claim 5, wherein color toning or pigmentation is present on the uppermost

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surface of the absorbent layer nearest the cover to mask undesirabl color or stain.

11. Apparatus for perforating a nonwov n web of fibrous fabric comprising fusible thermoplastic fibers, said apparatus comprising:

5 first and second movable members defining a nip therebetween through which the web is fed,

said first member carrying a plurality of outwardly projecting pins,

10 said second member including opening means arranged to receive the ends of said pins as said members are moved, so that said pins penetrate the fabric and separate the fibers thereof to form holes through the fabric, and

15 heating means for heating said pins and said opening means so that heat from said pins and opening means causes the separated nonwoven fibers to consolidate and set said fibers and prevent subsequent closing of the holes.

5 12. Apparatus according to claim 11, wherein said first and second members comprise rolls rotatable about generally parallel axes, said first roll including a sleeve upon which said pins are mounted, said second roll including a sleeve upon which said opening means are mounted, said heating means arranged to heat said sleeves so that said pins and said opening means are heated by conduction.

13. Apparatus according to claim 12, wherein said first roll is disposed above said second roll.

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14. Apparatus according to claim 11, wherein said opening means comprises a plurality of sockets alignable with respective ones of said pins.

15. Apparatus according to claim 11, wherein said pins each have a shaft diameter in the range of from about 0.015 inch to about 0.125 inch.

16. Apparatus according to claim 11, wherein more than one first member containing a plurality of outwardly projecting pins is present.

17. Apparatus according to claim 16, wherein three of the first members containing a plurality of outwardly projecting pins make contact with one of the second member including opening means.

18. A method of perforating a nonwoven web of fibrous fabric comprising fusible polymeric filaments, comprising the steps of:

5 passing the web through a nip defined by first and second movable members,

10 penetrating the fabric by means of heated pins projecting from one of said members and enter the heated opening means of the second member whereby said pins separate the fibers of said fabric to form holes therethrough, and whereby the heat from said pins causes the separated fibers to set and bond together to prevent subsequent closing of said holes.

19. A method according to claim 18, wherein portions of the fibers are pushed in the direction of said openings during said penetrating step to form rises surrounding each of said holes.

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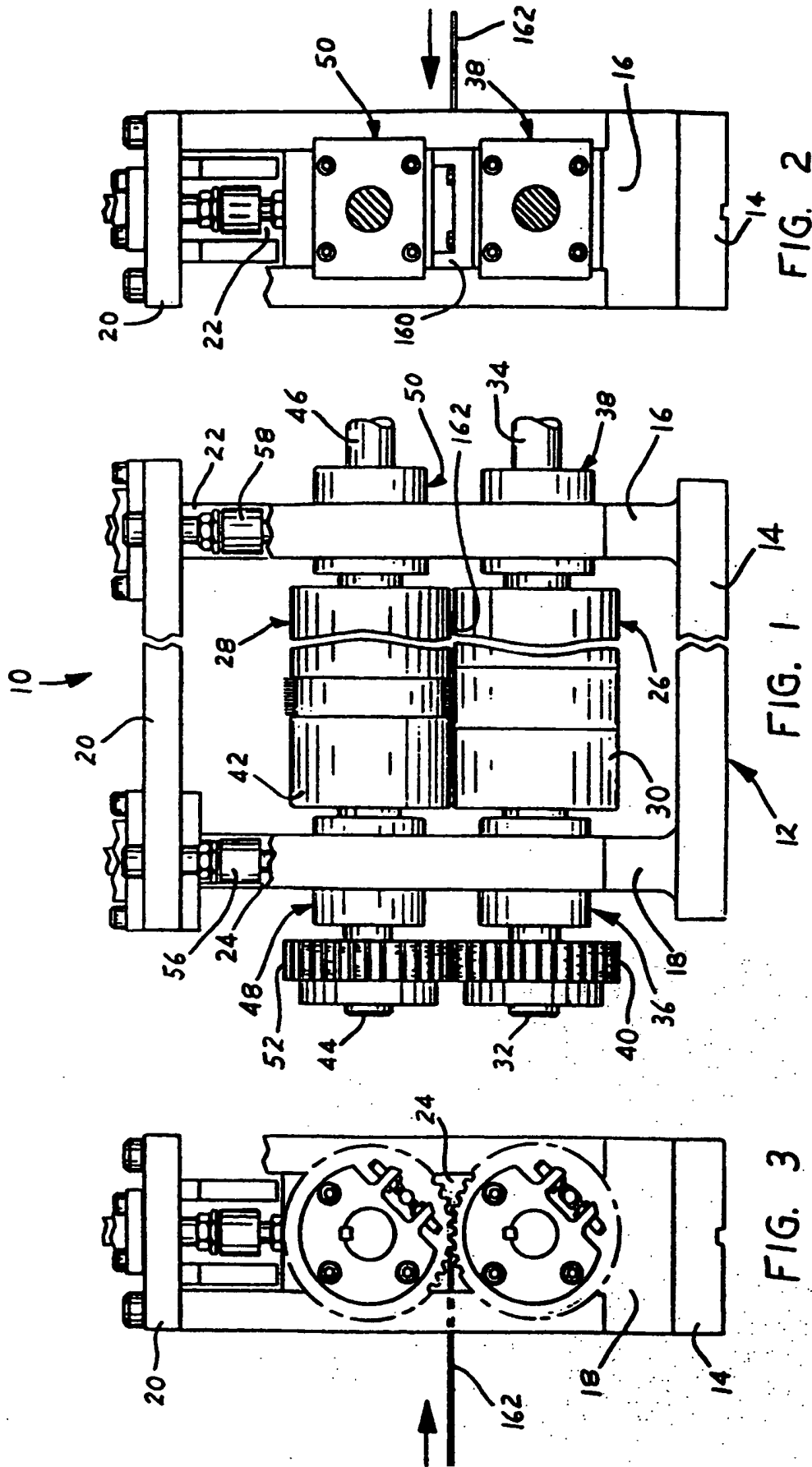
20. A method according to claim 18, wherein said pins are heated by heating a sleeve of each of said members upon which said pins and said opening means are carried.

21. A method according to claim 18, wherein said penetrating step includes the use of heated pins having a diameter in the range of from about 0.015 inch to about 0.125 inch.

22. A method according to claim 18, wherein said passing step comprises passing said web through a nip defined by first and second rotatable cylindrical rolls.

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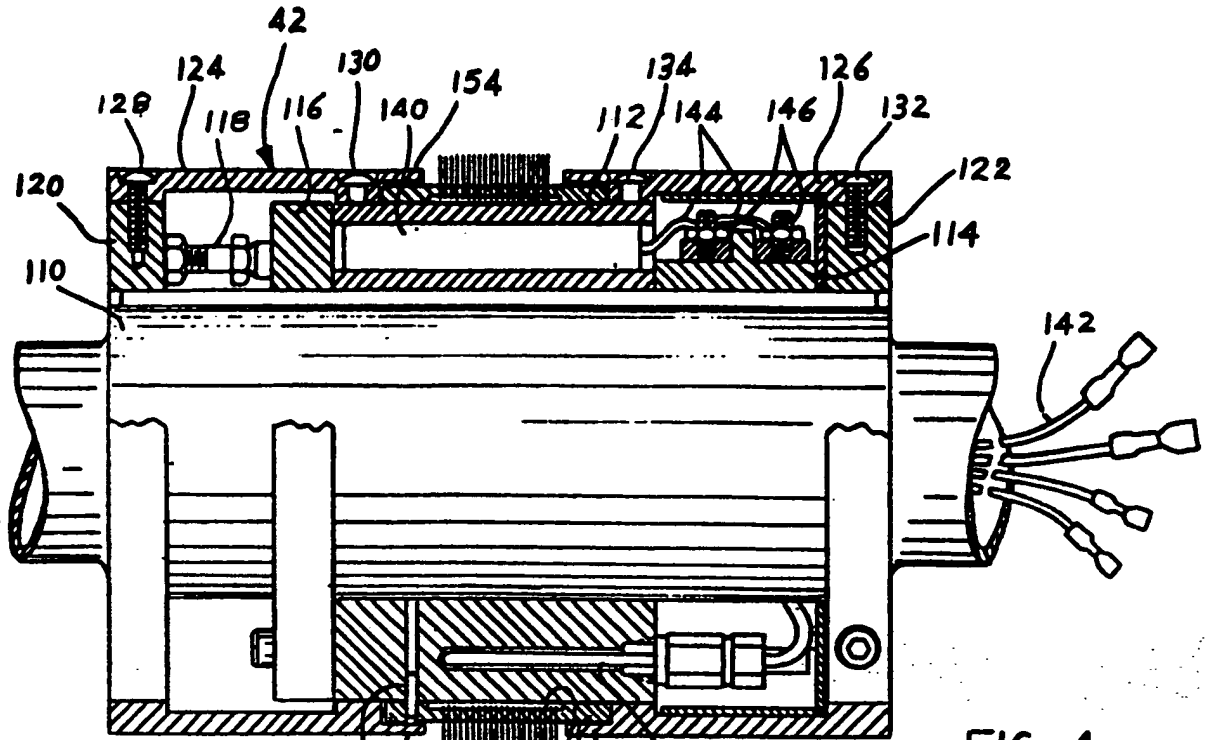


FIG. 4

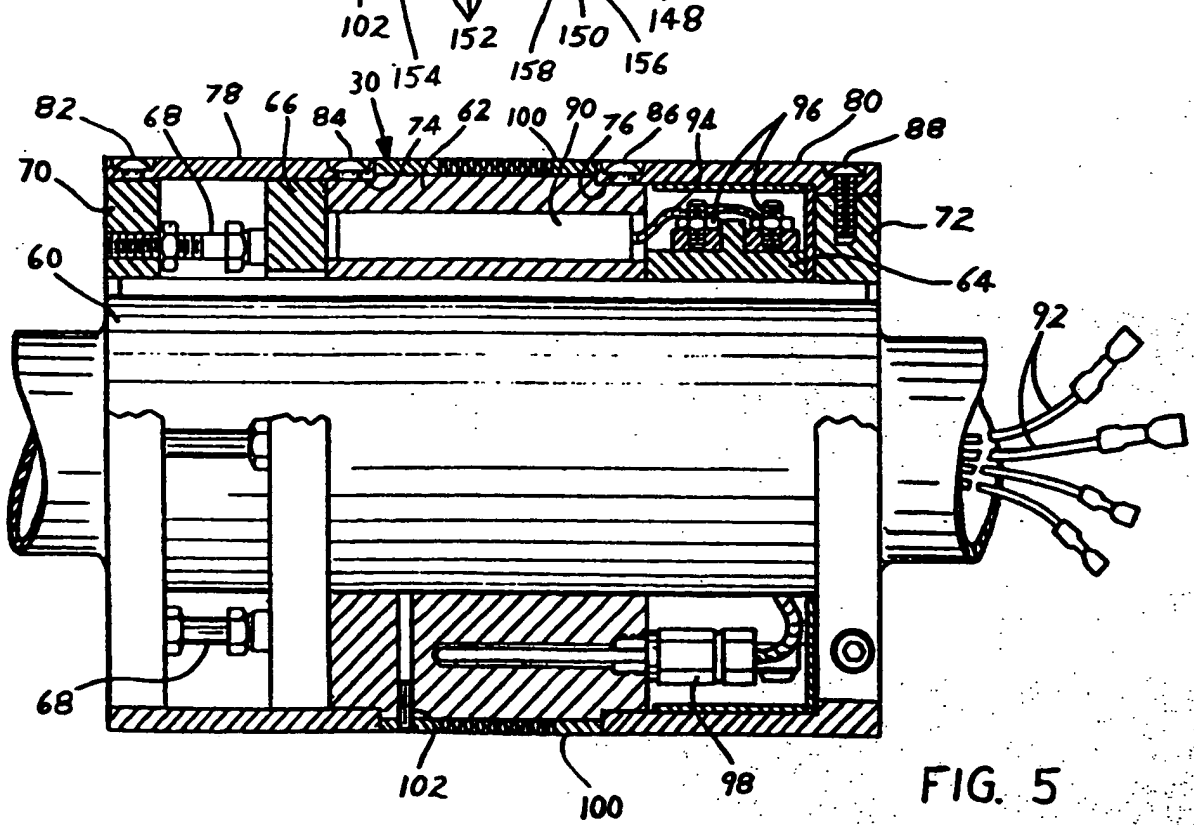
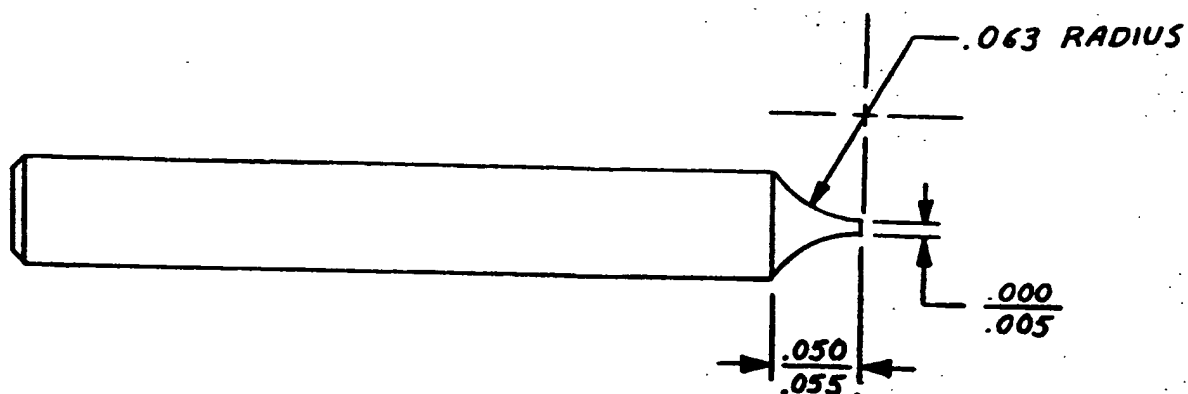
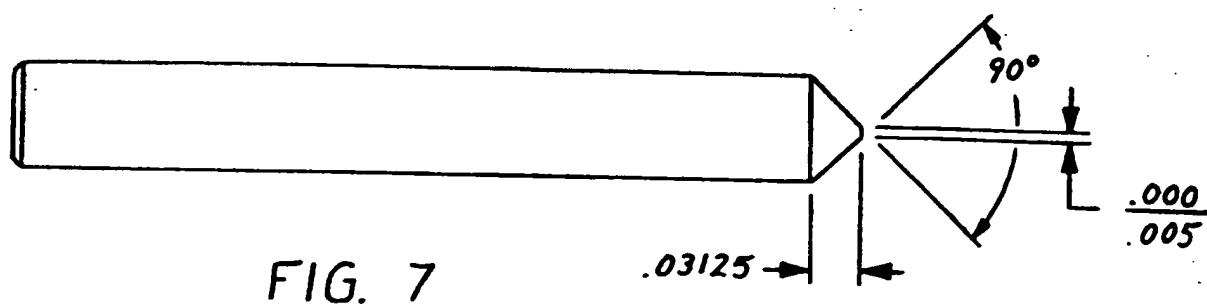
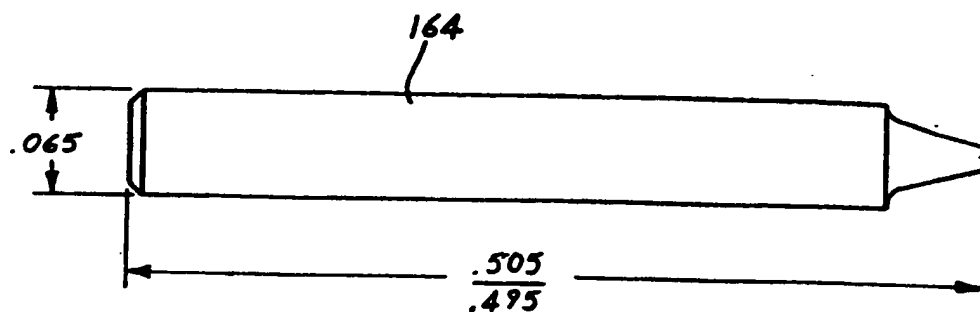


FIG. 5



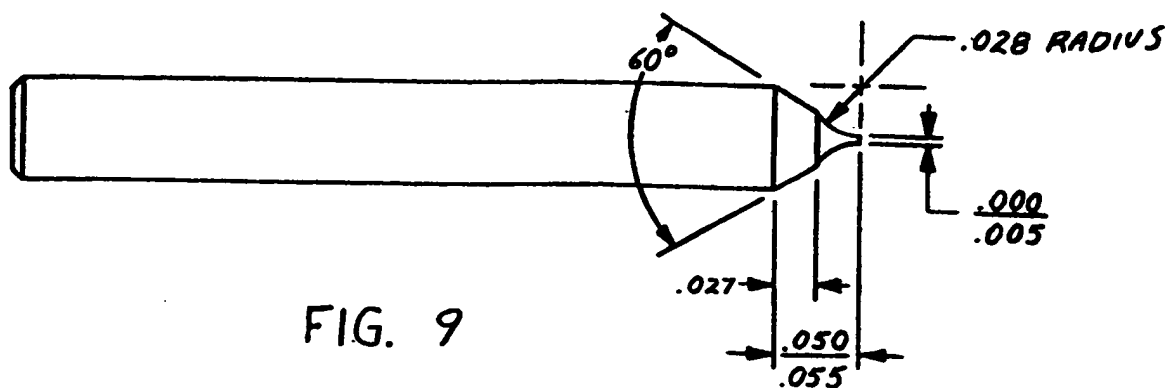


FIG. 9

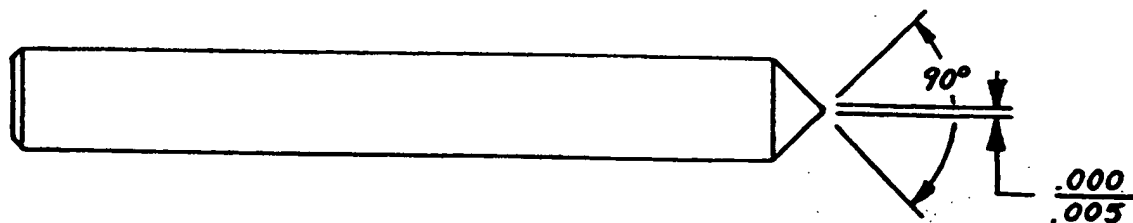


FIG. 10

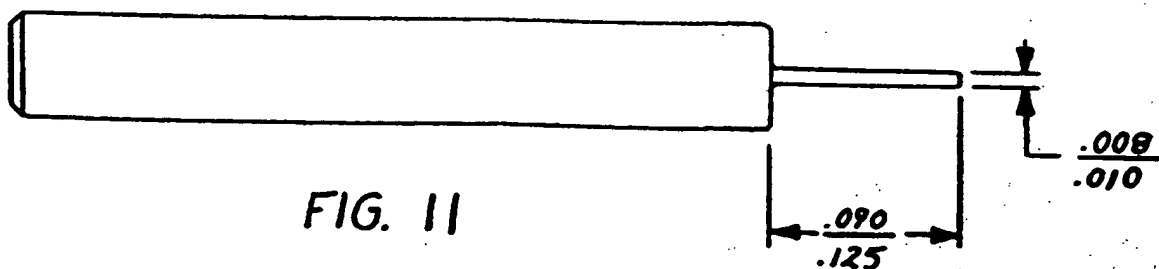


FIG. 11

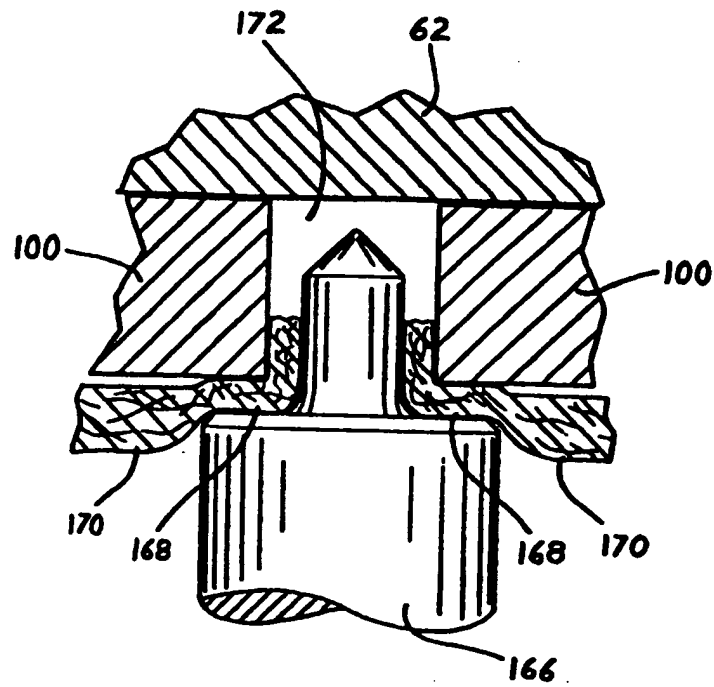


FIG. 12

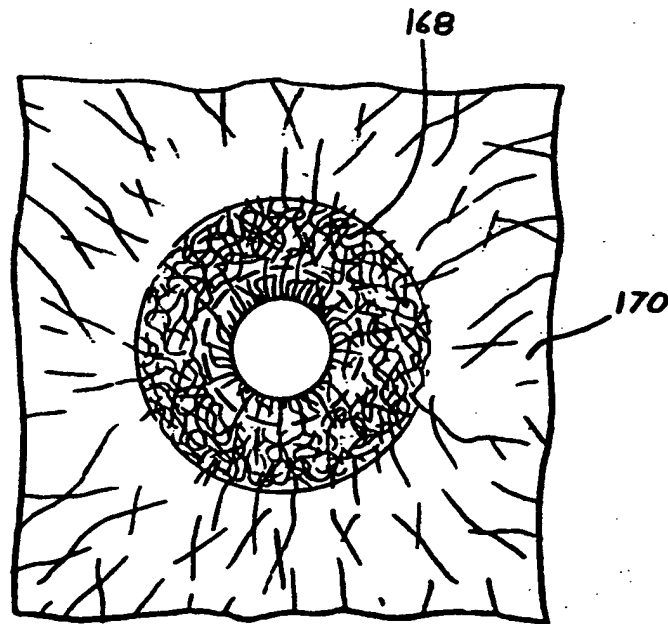


FIG. 13

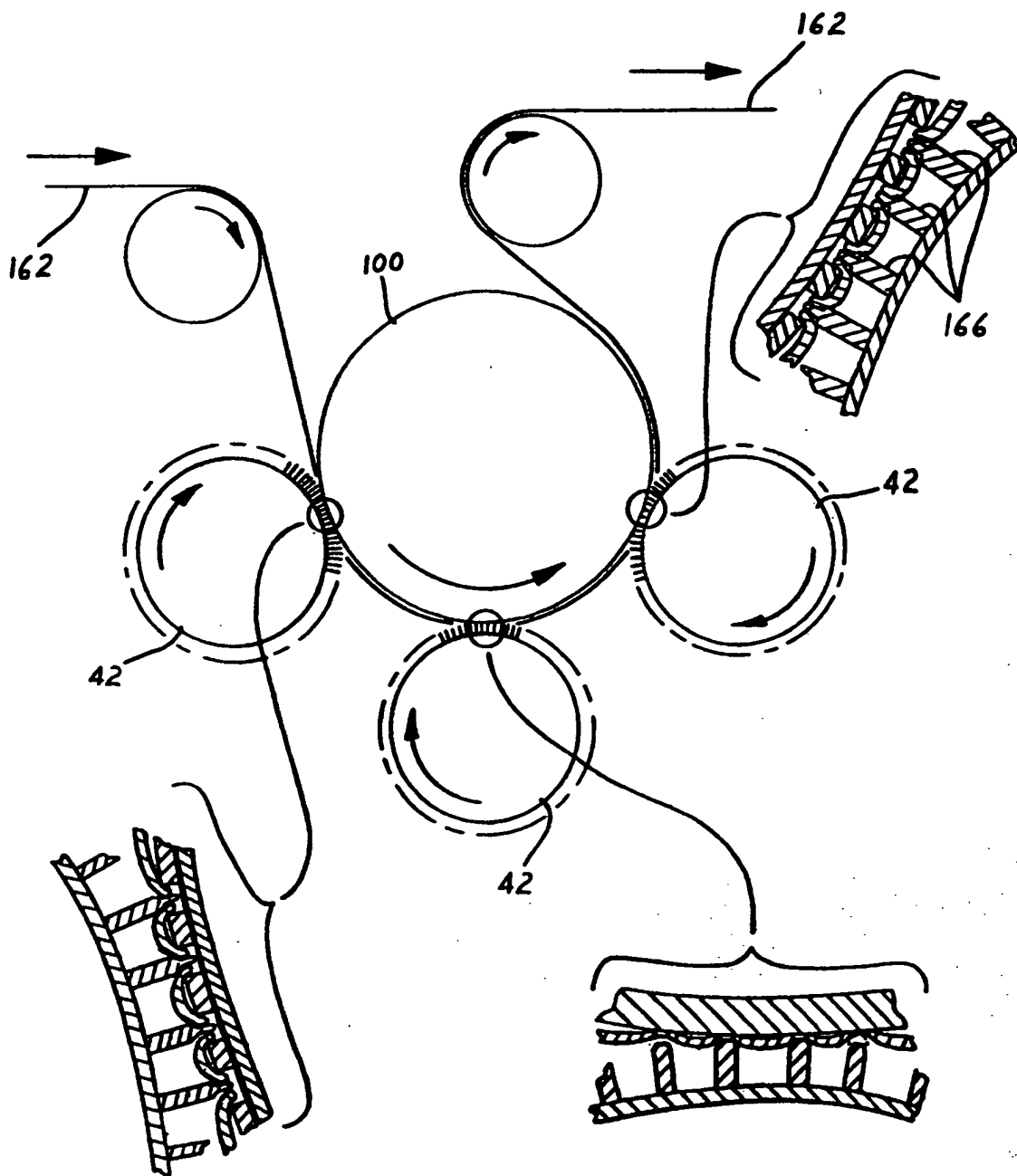


FIG. 14

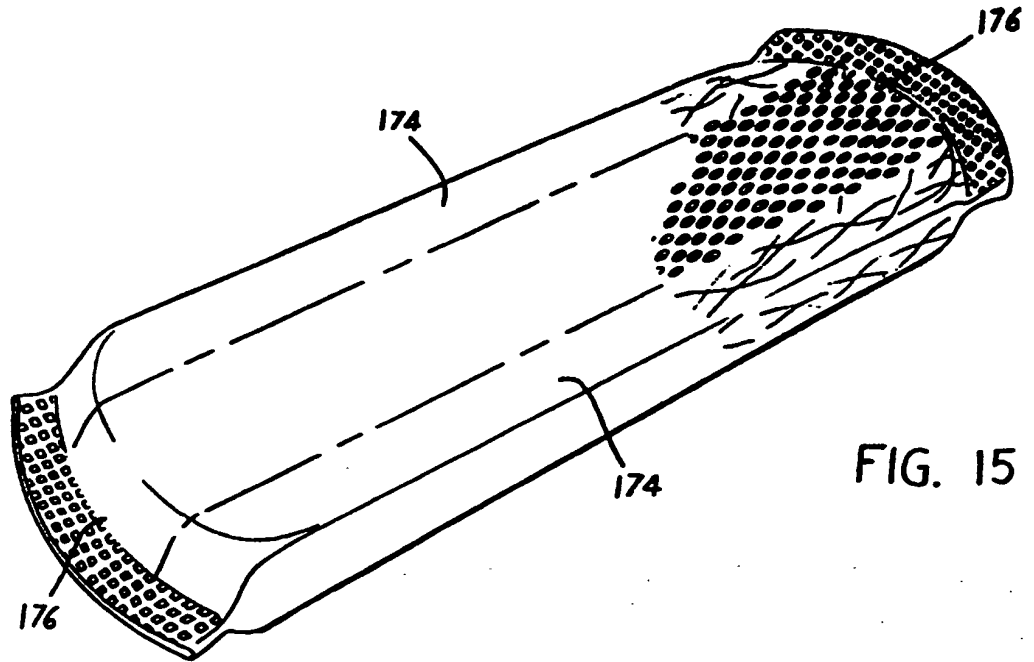


FIG. 15

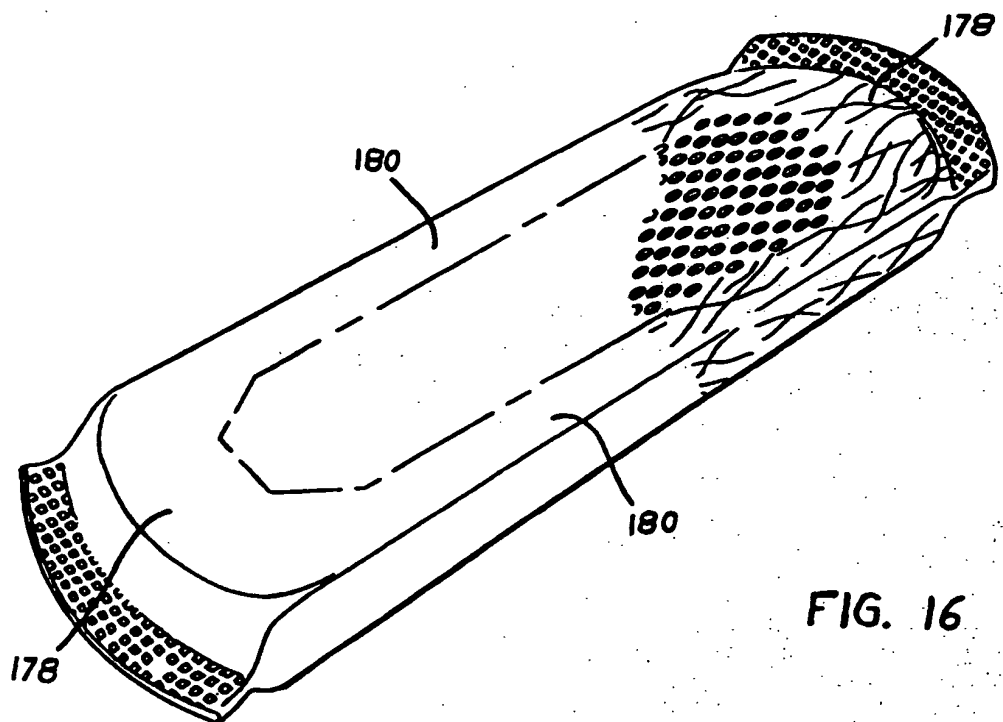


FIG. 16